

Blue

Dart Aerospace Ltd.

ay, 17/11/2008 1:54:18 PM  
Dawson

## Process Sheet

Job Number : CU-DAR001 Dart Helicopters Services  
Estimate Number : 43493  
P.O. Number : 10973  
This Issue : 17/11/2008 S.O. No. :  
Print Rev : NC  
First Issue : / / Type : CROSSTUBES  
Previous Run : 43476  
Written By :  
Checked & Approved By : JUD DS 11.17  
Comment :  
Est Rev:F 05.09.01 Add holes for compatibility with Bell  
Skidtubes KJ/JLM  
Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD  
verified by:ec  
Est Rev:H 08-07-18 remove thread masking in step 12 DD  
verified by:EC

Drawing Name : 206L AFT X-TUBE  
Part Number : D206667203BL  
Drawing Number : D206-667-243 REVB  
Project Number : N/A  
Drawing Revision :  
Material :  
Due Date : 02/02/2009 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0 D206667203TRN Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B-43533

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L AF and Folio FT

4.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

5.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 &amp; DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 &amp; DT8584 as per Dwg D206-667-243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/12/12

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-26	5-0	Side B is lower than 'A' but still within QS1412 tolerance, 0.020" lower.	<i>[Signature]</i> QS1412	Drill cuff B 20.76", and 'A' at nominal to even the tube.	<i>[Signature]</i> 08-11-27	S 08/12/12	<i>[Signature]</i> QS1412	<i>[Signature]</i> 08-11-26

NOTE: Date & initial all entries

Date: Monday, 17/11/2008 1:54:18 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 43493

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description:

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243  
Inside of Cuff (Donot engrave on outside of tube)

AWM 8-11-27 MB 08-11-27  
MB 08-11-27

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 8-11-27



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8 08/11/27 (P)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/11/27 (P)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



FD: 7725 C2081121020



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

10.0

PACKAGING1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

Signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206L AFT X-TUBE

Job Number: 43493

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

~~QES~~

DIMENSIONAL CHECK

QF



m 08 12 04 (1)



P70

Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY

109992

2-

-PAINT DELFLEET BLUE 110077

-CLEAR DELFLEET 109816

m 08 12 04 (1)

13.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

08-12-05 (1)

14.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 41987

ET 08-12-10

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 41988

ET 08-12-10

16.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 108076

ET 08-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-12-05	11-0	QCS required. Perm change				06-12-05	06-12-05

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43493

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 08-12-10

18.0 D3595075450 RUBBER CUSHION .75" x 4.50



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RUBBER CUSHION .75" x 4.50 341108

ml 08 12 09

19.0 D28921 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support 43385

ml 08 12 09

20.0 MS2192022 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp 108187

ml 08 12 09

21.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Magnabond B# 109900 exp. 02/2010 time: 9:10 AM

1-Install abrasion strips as per QSI-035 using DT8500. Note: (2) top holes should be facing up.

ml 08 12 09 (1)

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ml 08 12 10 (1)

22.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-12 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
05-12-12	210	Add Magna label to sequence. As per chng. Perm. Change	<i>[Signature]</i>	08/12/15		<i>[Signature]</i> 05-12-12	<i>[Signature]</i> 05-12-12

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Date: Monday, 17/11/2008 1:54:19 PM  
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## Process Sheet

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Drawing Name: 206L AFT X-TUBE

Job Number: 43493

Part Number: D206667203BL

Job Number:



Seq. #: Machine Or Operation: Description :

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

24.0 AN534A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
Batch: M109061

SP

25.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut  
Batch: M109297

SP

26.0 AN510A Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
10 AN5-10A Bolt M109280

SP

27.0 AN532A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
4 AN5-32A Bolt M109282

SP

28.0 AN960JD516 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)  
Pick:Packing Kit  
Qty Part number Description Batch  
18 AN960JD516 Washer M109282

8/10/10

Q

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L AFT X-TUBE

Job Number: 43493

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

40812-12 ①

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: D

PPP Rev: D

40812-12 ①

31.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

40812-12

Job Completion



40812-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

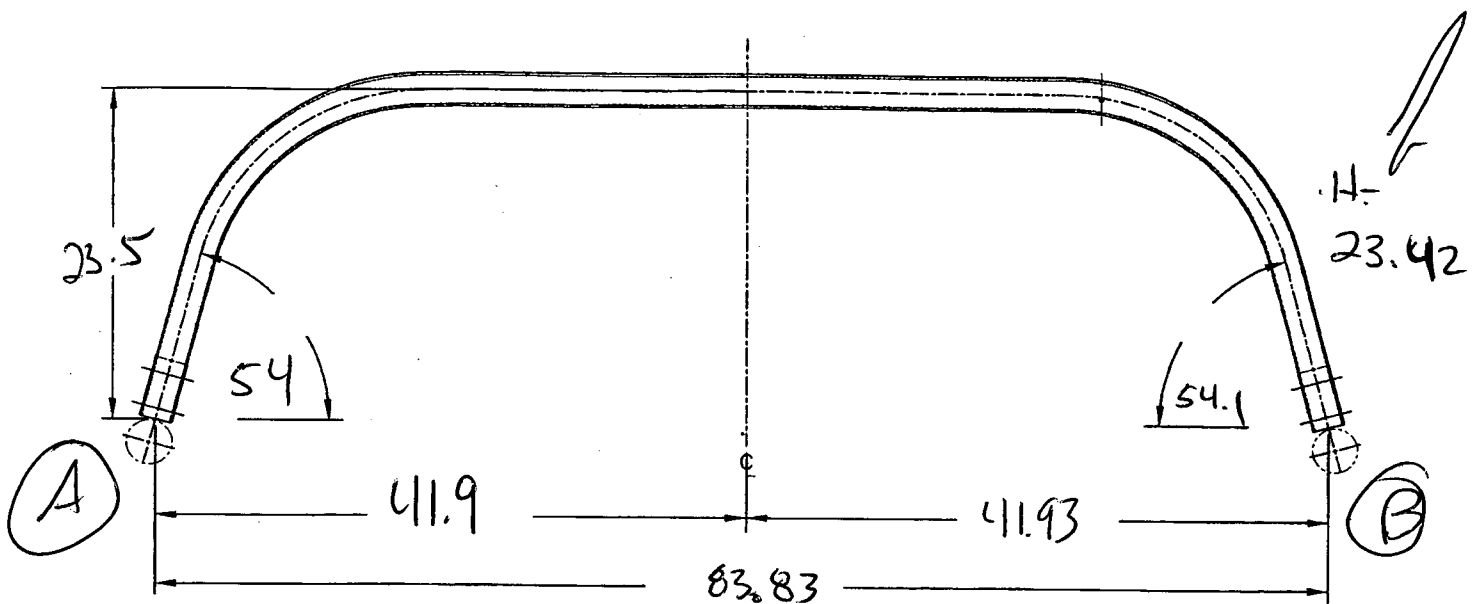
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 43493
Description: Crosstube High Aft (206L)		Part Number: D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
Drill side B at .700"

QC15 Inspection	QSIWZ
Date	08-11-26

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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WORK OF THE  
NO. 43493

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

D

C

B

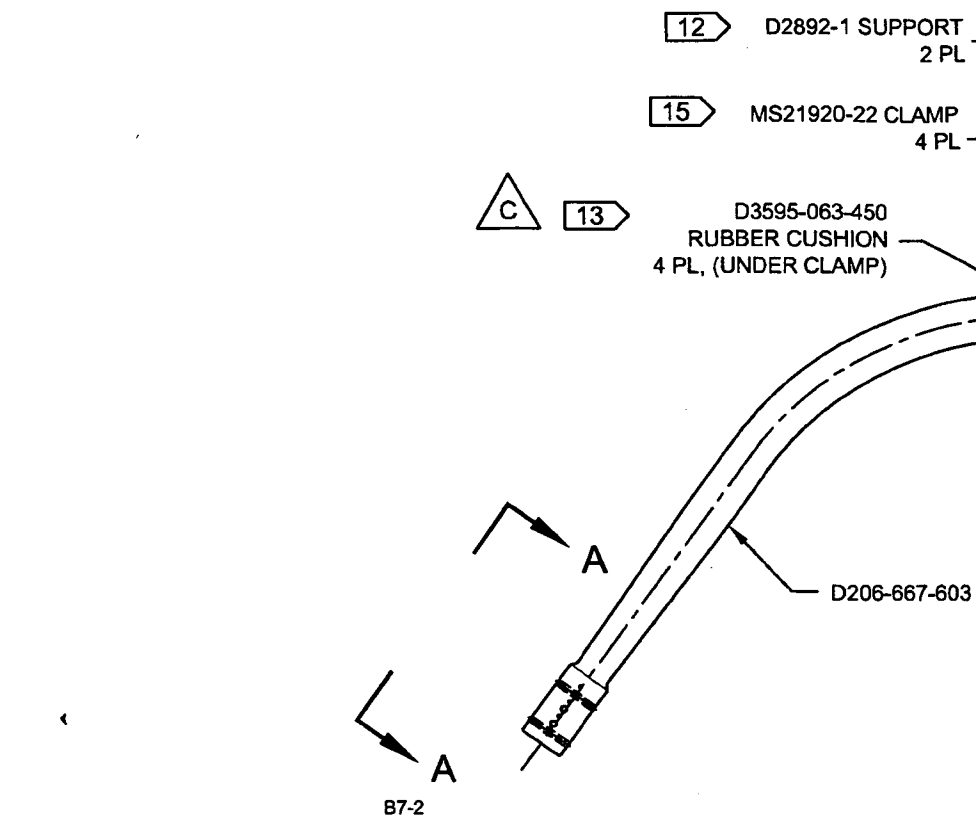
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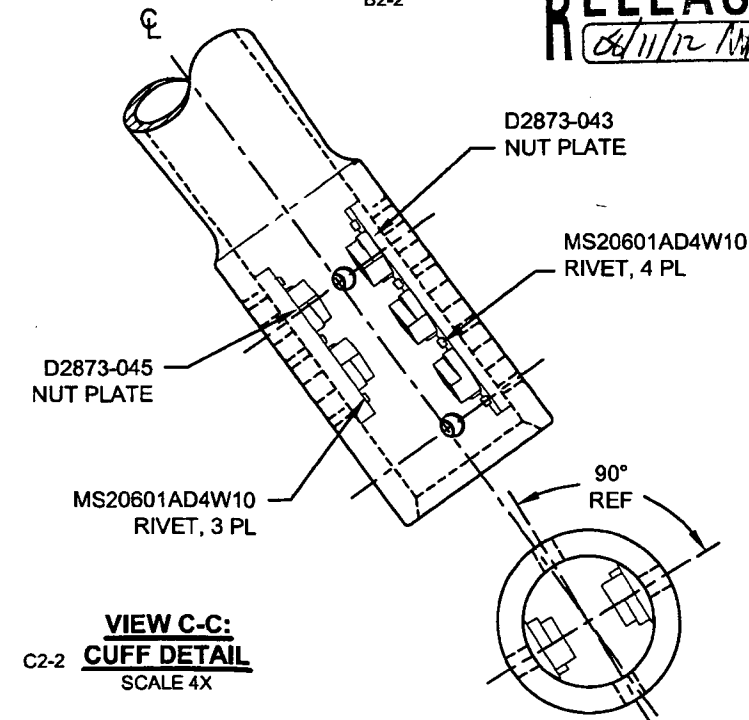
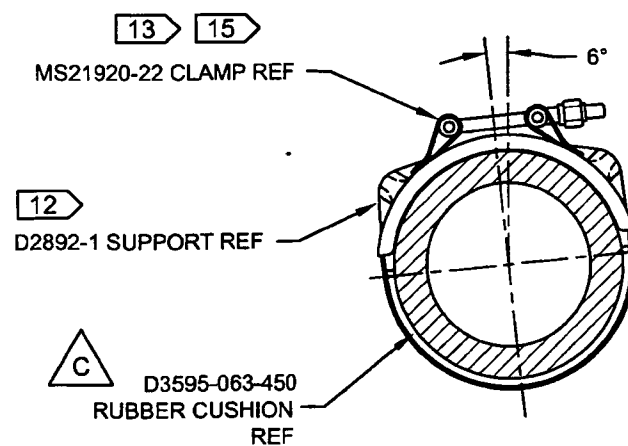
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**D206-667-243  
ASSEMBLY DETAIL  
(VIEW LOOKING FWD)**



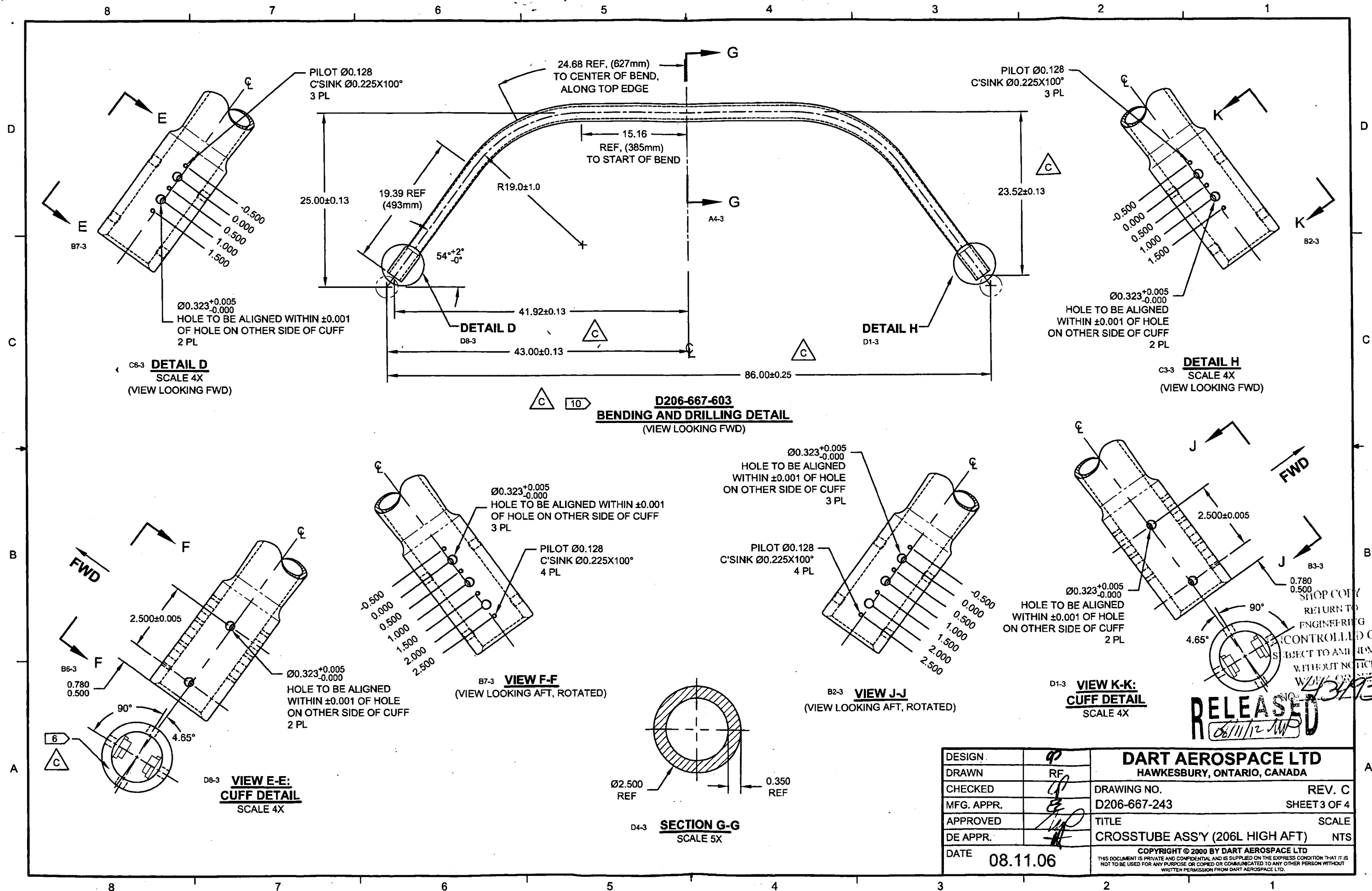
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08/11/06

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NOTICE  
43493

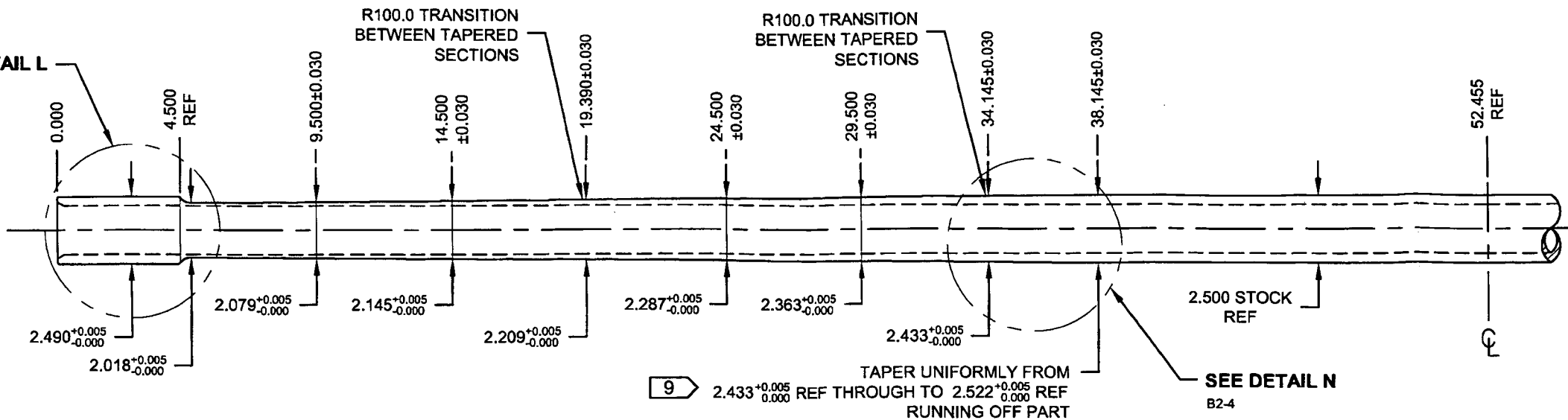
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-243	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
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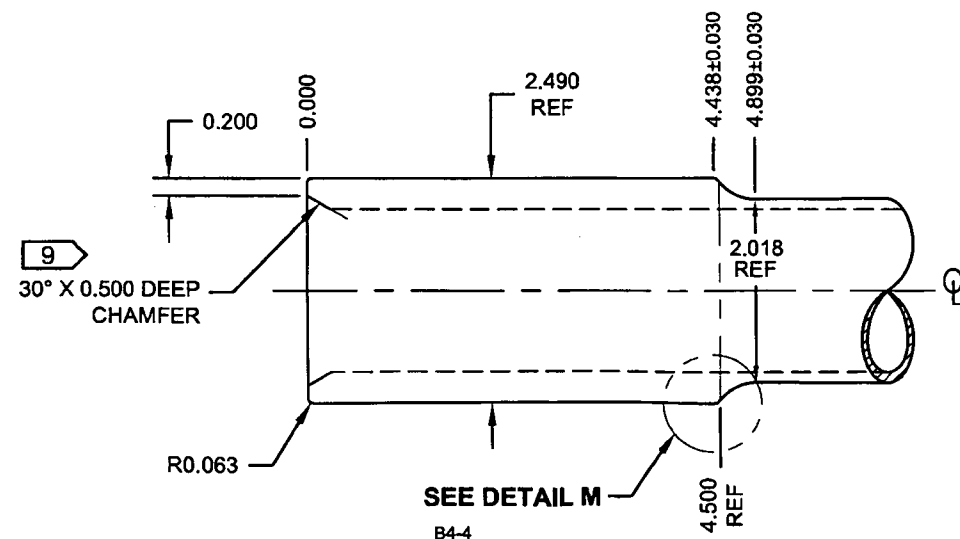




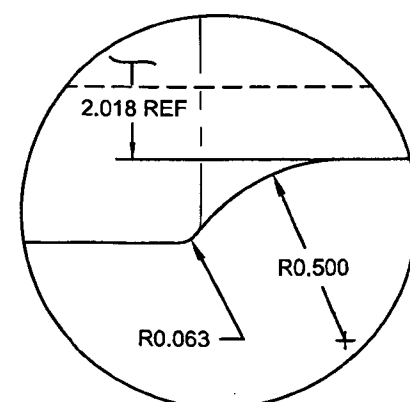
SEE DETAIL L  
B7-4



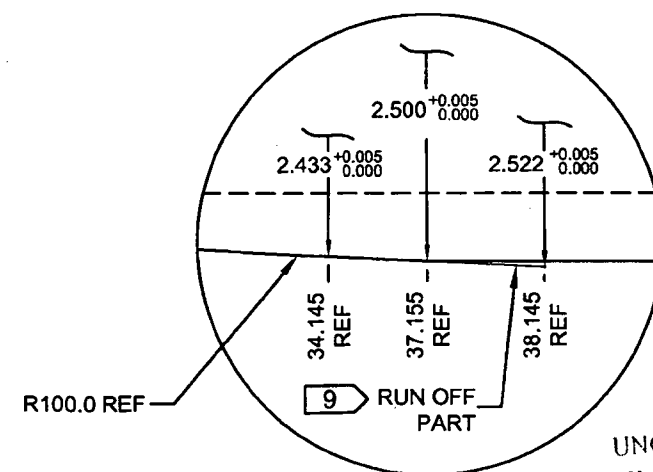
**TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 243493

**RELEASED**  
08/11/12

DESIGN	40	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-243	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
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Date: Wednesday, 19/11/2008 9:03:43 AM  
User: Julie Dawson

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<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206L AFT X-TUBE
<b>Job Number</b>	: 43493		
<b>Estimate Number</b>	: 10973		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206667203BL
<b>This Issue</b>	: 19/11/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D206-667-243 REV B
<b>First Issue</b>	: 17/11/2008	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 43476	<b>Drawing Revision</b>	:
	<b>Type</b> : CROSSTUBES	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 02/02/2009
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DS19415 (ECN1198) DD verified by:ec Est Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC		

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JUD 08.12.05



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0	D206667203TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
CROSSTUBE TURNING DETAIL  
batch \_\_\_\_\_

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT \_\_\_\_\_

Job Completion

